

Work Order ID 70791

Wednesday, June 15, 2011 10:56:23 AM



Page 1

Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 6/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 6/15/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2348

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B11-6-23

(30)

6061 . 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 6/16/23

count
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



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Item Name: Wearplate
Start Date: 6/15/2011 Start Qty: 16.00  Cust Item ID:
Required Date: 6/22/2011 Req'd Qty: 16.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Outsource4	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
Outsource process - Anodize	Memo Issue P/O: <u>143666</u> Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached	0.00							<u>CX 11106/24</u> <u>(30)</u>
160  Packaging	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo Ensure certificate of conformity is attached	0.00							<u>Pack/ (30)</u>
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo INSPECT CERTS	0.00							<u>Counts</u> <u>(x30)</u>

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Item Name: Wearplate

Start Date: 6/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Install Insert as per Dwg D2348

ES 11/08/16 (30)

190



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8/6/16

counted
(x30)

200



Packaging

Identify as per dwg & Stock Location: 11

0.00

Memo

0.00

Packaging

11/8/16 300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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Work Order ID 70791

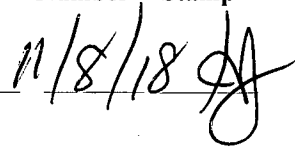
Page 4

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Revision ID: Stop 
Item Name: Wearplate
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Required Date: 6/22/2011 Req'd Qty: 16.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/8/18 
11-08-14
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 10:56:31 AM

Page 1

Work Order ID: 70791

Parent Item: D2348

Parent Item Name: Wearplate



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063 		Purchased	No			100	sf	251.6700	0.0198	0.333474	16		
											B11-6-23		

6061-T6 .063 Sheet

Location	Loc Qty	Loc Code
MAT021	251.67	
116308	29	
117285	222.67	

D3996-FE-832-EF		Manufactured	No			180	Each	109.0000	4	64			
											117285		
											5/28/16		

Self-Clinching Fastener

Location	Loc Qty	Loc Code
ST103	109	
67908	109	

B71756 9x

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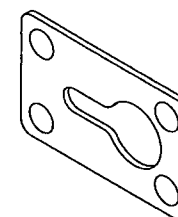
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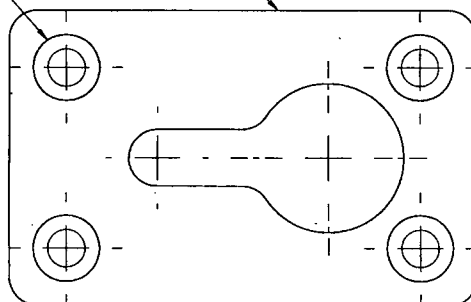
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER



D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

D2348F



D2348 WEAR PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70791

11-06-15

RELEASED
2009-11-09
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>97</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D2348	SHEET 1 OF 2
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

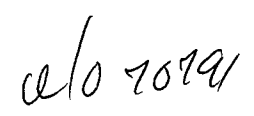
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RELEASED
2009-11-08

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	99	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	6	DRAWING NO.	REV. C
MFG. APPR.	10	D2348	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN AUTHORIZATION OF DART AEROSPACE LTD.	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14366

Purchase Order Date 6/24/2011

PO Print Date 6/24/2011

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 429 7777	Requisition Nbr	
Vendor Fax	514 429 5108	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
CL/10/24

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	70791	D2348 WEARPLATE	6/30/2011 Yes	30.00	FedEx PI collect	\$3.3333	\$100.00

Special Inst: BLACK ANODIZE AS PER MIL-A-8625F
TYPE I/IBOR IC/II/IIB
CLASS 2

PO Total:

\$100.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 6/24/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Packing Slip

21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2
Canada
Phone: 514-429-7777 Fax: 514-429-5108
Email: info@tnminc.ca

DATE

PACKING SLIP #

7/6/2011

- 89493



BILL TO:

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
PO14366	0094	NET 30		7/6/2011	Purolator		131286-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
30	30	0	P/N: D2348 TNM-REV: P1 Minimum Charge

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité est limitée à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoice costs.

Packing Slip



Anodisation & Peinture TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 89493



7/6/2011

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

PURCHASE ORDER /
NO. DE COMMANDE:

PO14366

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	30	30	P/N:D2348 TNM-REV:P1 70791 MAT'L: ALUM	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8 n107/08

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: ~~Les~~ pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: _____



Directeur de la Qualité / Q.A. Manager